Monday, 3/17/2008 11:56:54 AM Date User: Kim Johnston Customer : CU-DAR001 Dart Helicopters Services Job Number : 38026 : 10509 **Estimate Number** P.O. Number : 3/17/2008 S.O. No. : This Issue Prsht Rev. : NC : 11 First Issue Type : 36533 Previous Run Written By Checked & Approved By : Est:D Comment

Process Sheet

Drawing Name

: MOUNTING ANGLE

Part Number

: MACHINED PARTS

: D2564 D2564 REV. B1 **Drawing Number**

: N/A Project Number : B1 **Drawing Revision**

Material

Due Date : 4/10/2008 Qty: 50 Um: Each

02.09.09 Re-format; Added FA276 Folio KJ/RF

Additional Product

1.0

3.0

Job Number:

Seq. #: Machine Or Operation: D6207

Description:

Angle Extrusion 1x1x.125

Comment: Qty.: 0.0962 f(s)/Unit Total:

4.8090 f(s)

Angle Extrusion

Material: D6207 (1" x 1" x .125 angle) 6061-T6/T6511 (QQ-A-200/8)

Batch: B37670

BAND SAW 2.0

HAAS1

BAND SAW

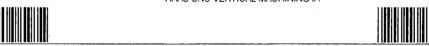


Comment: BAND SAW

Cut D6207 Extrusion: 1.00" Long (+0.000/-0.030)

HAAS CNC VERTICAL MACHINING #1





Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA276 Rev: A & Dwg D2564 Rev:

2-Deburr if necessary

4.0 QC2



PARTS AS THEY COME OFF MACHINE Comment: INSPECT

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

Dart Ae	rospace	e Ltd								
W/O:			WO	RK ORDER CHANGES						
DATE	STEP	PRO	OCEDURE CHAN	IGE	By Date Qty C			Approval Chief Eng / Prod Mgr	roval f Eng / d Mgr Approval QC Inspector	
									:	
		·								
Part No	:	PAR #:	Fault Categ	ory: l	NCR: Yes	No DQ	A :	Date:		
					QA: N	/C Close	d:	Date:		
NCR:		V	WORK ORDE	R NON-CONFORMAN	CE (NCF	R)				
		Description of NC		Corrective Action Section B		Verific	Verification	Approval	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Secti		Chief Eng	QC Inspector	

NOTE: Date & initial all entries

Date: Monday, 3/17/2008 11:56:54 AM Kim Johnston User: **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services Drawing Name: MOUNTING ANGLE Job Number: 38026 Part Number: D2564 Job Number: Seq. #: Description: **Machine Or Operation:** PACKAGING 1 PACKAGING RESOURCE #1 6.0 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 7.0 QC21 Comment: FINAL INSPECTION/W/O RELEASE m= 08-03-28 Job Completion

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES									
DATE	STEP		PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
Part No	·	PAR :	#: Fault Category:	NCR: Yes	No DQ	A:	_ Date: _				
				QA:	N/C Close	d:	Date: _				
NCR:			WORK ORDER NON-CON	FORMANCE (NC	R)			 			

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
	STEP	Description of NC		Verification	A 1						
DATE		Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector			
		·					<i>*</i> .				

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	38026
Description: Mounting Angle	Part Number:	D2564
Inspection Dwg: D2564 Rev: B1		Page 1 of 1

	X	First Artic	le	Proto	type		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Con	nments
1.00	+/-0.030	1.014	/				
0.625	+/-0.010	-625					
Ø0.257	+/-0.010	0,258					
1.000	+/-0.010	1996	//				,
1.000	+/-0.010	358					
R0.375	+/-0.010	12.375					-
easured by:	12	Audited by:	815		Prototype App	roval:	N/A
Date:	38/03/27	Date:	08/03/	27		Date:	N/A

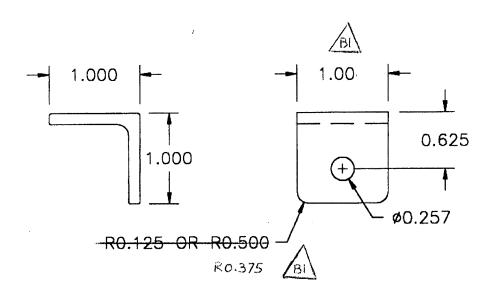
IIICUS	area sy.		Addition by:	1 lototype Approval.	13/73
	Date:	08/03/27	Date: 08/03/27	Date:	N/A
		,			
Rev	Date	Change		Revised by	Approx/ed
A	04.06.10	New Issue		KJ/JLM م	- 7/1
				, ()	





١	DESIGN DRAWN BY		DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA				
1	MIKE	MIKE M MIKE M						
1	CHECK		APPROVED_	DRAWING NO. REV	/. B			
	B	L	BW	D2564 SHEET 1 C)F 1			
	DATE		<u> </u>	TITLE	ALE			
	96:0	4:30		MOUNTING ANGLE	1:1			
	В		97:05:06	MODIFIED DIMENSIONS				
	BI	dR	02.09.17	RO.375 WAS RO.125 OR RO.500 ;				
				1,00 WAS 1,000				

RELEASED Payospos BW



NOTES

MATERIAL: 6061-T6 ANGLE 1.0 X 1.0 X 0.125

MAKE FROM DE207-XXX ANGLE EXTRUSION

- 2) BREAK ALL SHARP EDGES 0.005 0.015
- 3) TOLERANCES PER DART ESI DIS UNLESS OTHERWISE NOTEDSHOP COPY
- 4) ALL DIMENSIONS ARE IN INCHES

RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

NO. 38036